

Date: Monday, 7/9/2007 11:39:50 AM
User: Kim Johnston

Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP (CASTING DETAIL)
Job Number : 33321 - 1	
Estimate Number : 10510	
P.O. Number :	Part Number : D25763
This Issue : 7/9/2007 S.O. No. :	Drawing Number : D2576 REV 1 2
Prsht Rev. : NC	Project Number : N/A
First Issue : 7/6/2007 Type : PURCHASED PARTS	Drawing Revision : 1 2
Previous Run : 31925	Material :
Written By :	Due Date : 7/24/2007 Qty: 100 Um: Each
Checked & Approved By :	
Comment : Est: E 02.08.19 Consolidated D2576-1 and D2576-3 KJ/RF	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25761 Step (Casting Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
1	D2576-1	Step (Casting Detail)	33321

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS1

1- Machine as per Folio FA332 and Dwg D2576
2- Deburr

8.F 08-01/31

BE 08-01-30

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BE 08-01-30 / 8.F 08/01/31

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 08/01/31

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: LG

BE 08/01/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 08/02/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:39:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 33321

Part Number: D25763

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(25)

Comment: FINAL INSPECTION/W/O RELEASE

DD 08/02/01

Job Completion



2008/1/31

(25)

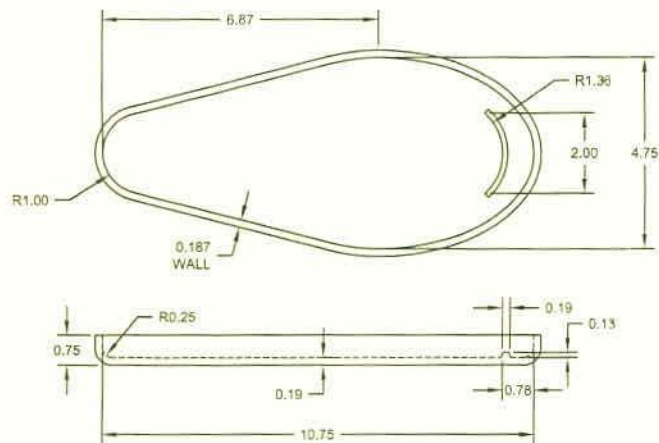
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

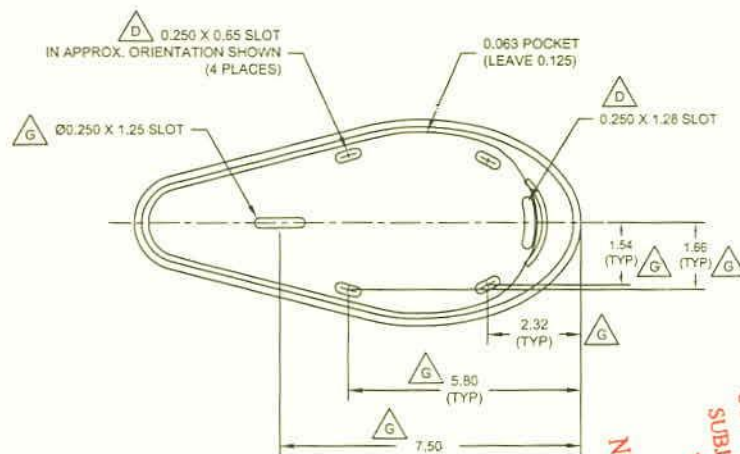
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

RELEASED

07.08.21

REV.	DESCRIPTION	BY	DATE
G	CHANGE SLOTS LOCATION AND SIZE ON D2576-3 DUE TO SKID BENDING PROGRAM CHANGES UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.08.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2576
TITLE STEP
REV. G
SHEET 1 OF 1
SCALE 1:3

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NO. 33321
WORK ORDER
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